

Date: Wednesday, 12/14/2005 3:58:12 PM
 User: Kim Johnston

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BASKET LID ASSEMBLY |
| Job Number : 25230B | |
| Estimate Number : 10207 | |
| P.O. Number : N/A | Part Number : D2989043 |
| This Issue : 12/14/2005 S.O. No. : N/A | Drawing Number : D2989 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : LARGE FAB ASSY | Drawing Revision : B |
| Previous Run : 24825B | Material : N/A |
| Written By : SEE COMMENT BELOW | Due Date : 1/20/2006 Qty: 1 Um: Each |
| Checked & Approved By : SEE COMMENT BELOW | |
| Comment : Est Rev:l Removed D2989-041 05-11-03 JLM | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|-------|
| 1.0 | D31821 | Hinge |
|-----|--------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

| | | |
|-----------------|-------------|--------|
| Qty Part number | Description | Batch |
| 2 D3182-1 | Hinge | B23085 |

PD 06-01-25

| | | |
|-----|--------|------|
| 2.0 | D34423 | Shim |
|-----|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

| | | |
|-----------------|-------------|--------|
| Qty Part number | Description | Batch |
| 2 D3442-3 | Shim | B23545 |

PD 06-01-25

| | | |
|-----|--------------|--------------------------|
| 3.0 | M304EX07516F | Expanded Metal Flat Stai |
|-----|--------------|--------------------------|



Comment: Qty.: 8.0000 sf(s)/Unit Total: 8.0000 sf(s)

Pick:

| | | |
|---------------------|----------------|--------|
| Qty Part number | Description | Batch |
| 15sf M304EX0.75-16F | Expanded Metal | H19615 |

PD 06-01-25

| | | |
|-----|----------------|--------------------------|
| 4.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |
|-----|----------------|--------------------------|



Comment: Qty.: 17.6400 f(s)/Unit Total: 17.6400 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: B19447

PD 06-01-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 12/14/2005 3:58:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 25230B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

PD 06/01/31

6.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

06/01/31

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

FC 06/02/06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

06/02/07

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/02/07

Job Completion



06/02/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 06/02/07
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------|----------------|--|------------------------|
| DESIGN DS | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D2989 | REV. B SHEET 1 OF 3 |
| DATE 05.06.07 | | TITLE BASKET LID ASSEMBLY | SCALE NTS |
| A | 00.10.27 | NEW ISSUE | |
| B | 05.06.07 | ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS | |

RELEASED

05-08-19 H

PARTS LIST:

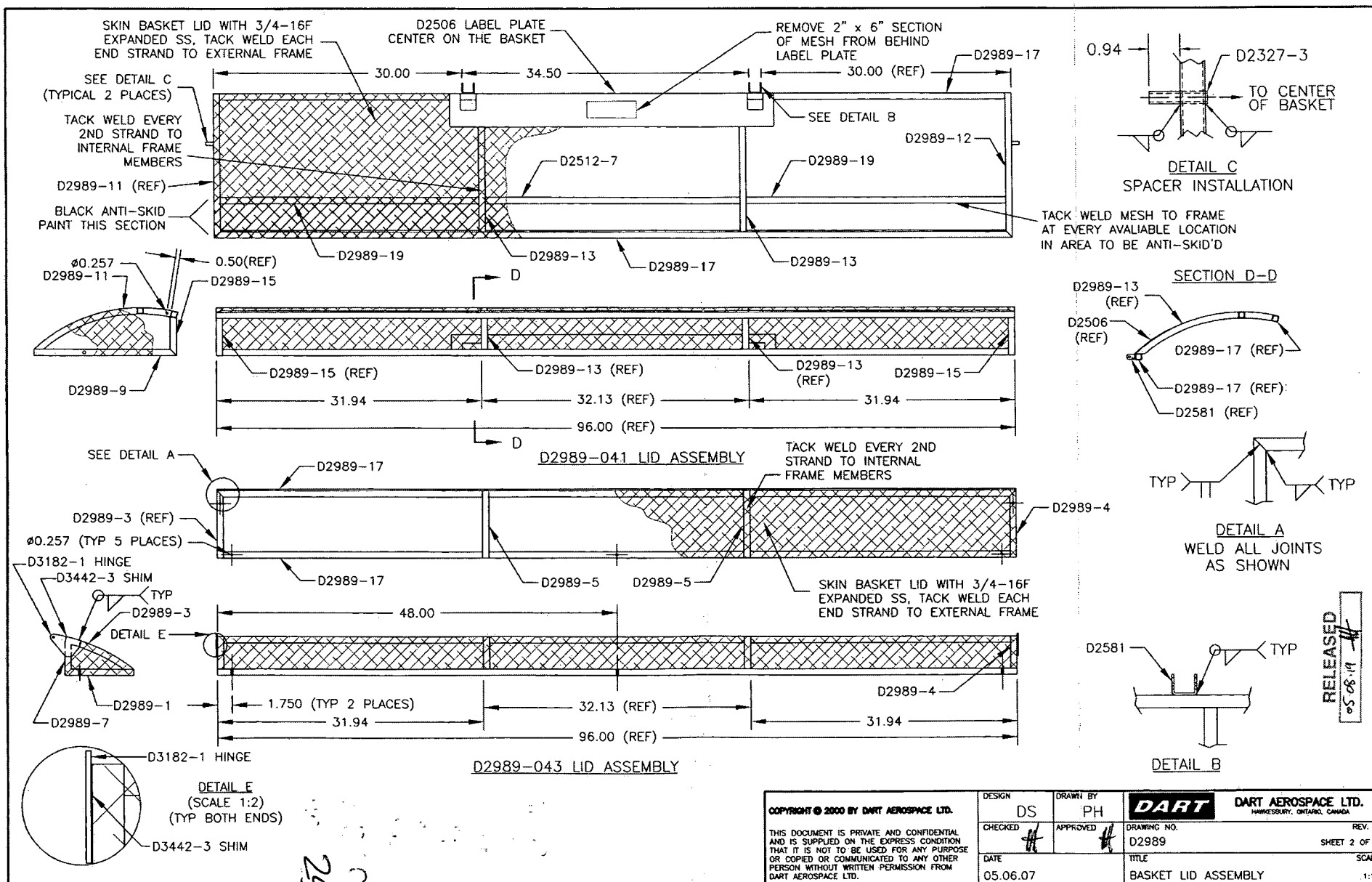
| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|-------------|-------------------------------|
| X | | D2989-041 | BASKET LID ASSEMBLY (OUTSIDE) |
| | X | D2989-043 | BASKET LID ASSEMBLY (INSIDE) |
| | 1 | D2989-1 | STRUT |
| | 1 | D2989-2 | STRUT |
| | 1 | D2989-3 | STRUT |
| | 1 | D2989-4 | STRUT |
| | 2 | D2989-5 | STRUT |
| | 2 | D2989-7 | STRUT |
| 1 | | D2989-9 | STRUT |
| 1 | | D2989-10 | STRUT |
| 1 | | D2989-11 | STRUT |
| 1 | | D2989-12 | STRUT |
| 2 | | D2989-13 | STRUT |
| 2 | | D2989-15 | STRUT |
| | | | |
| 2 | | D2327-3 | SPACER BUSHING |
| 1 | | D2506 | LABEL PLATE |
| 2 | 2 | D2989-17 | STRUT (96.00" LONG) |
| 2 | | D2989-19 | STRUT (31.19" LONG) |
| 1 | | D2512-7 | STRUT |
| 2 | | D2581 | MOUNTING BRACKET |
| | 2 | D3182-1 | HINGE |
| | 2 | D3442-3 | SHIM |

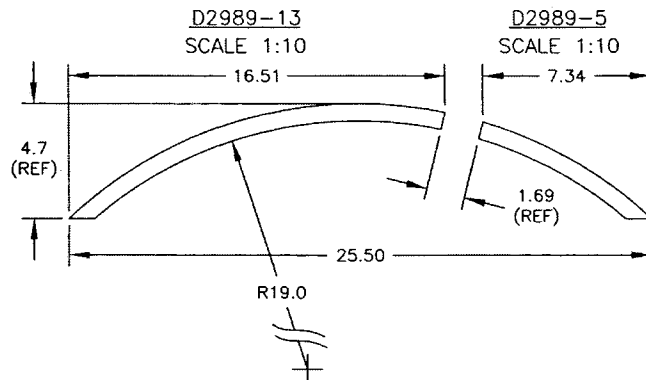
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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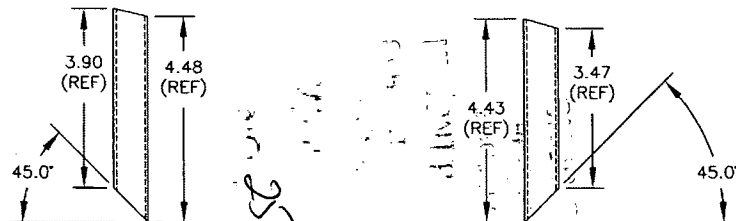
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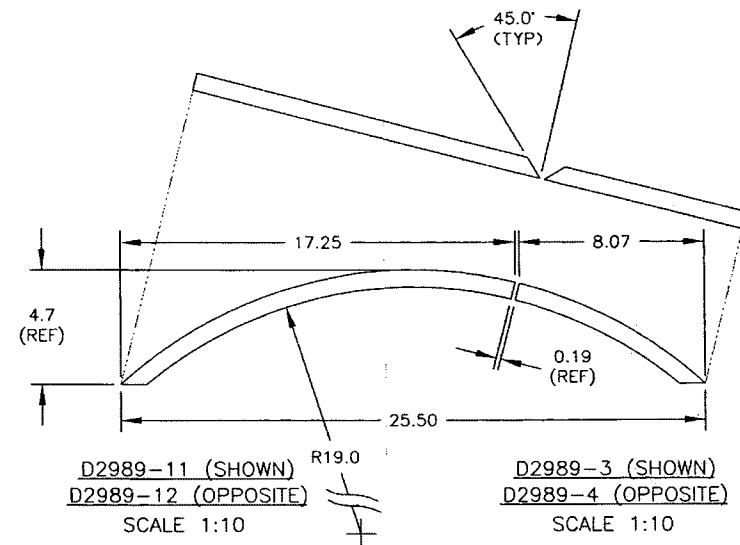
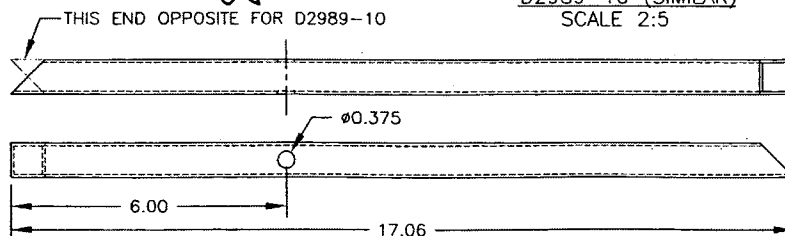


D2989-15
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

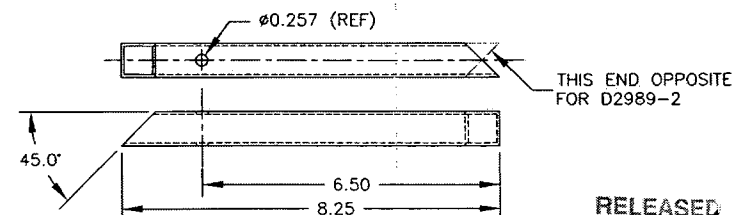
D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-9 (SHOWN)
D2989-10 (SIMILAR)
SCALE 2:5



D2989-1 (SHOWN)
D2989-2 (OPPOSITE)
SCALE 2:5



THIS END OPPOSITE
FOR D2989-2

RELEASED

05.08.19

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| | | | | | |
|---------|----------|----------|---------------------|-------------|--|
| DESIGN | DS | DRAWN BY | PH | DART | DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA |
| CHECKED | # | APPROVED | # | DRAWING NO. | D2989 |
| DATE | 05.06.07 | TITLE | BASKET LID ASSEMBLY | REV. B | SHEET 3 OF 3 |
| | | | | SCALE | 1:10 |